

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029461**Date Inspected:** 29-Apr-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**Contractor:** American Bridge Manufacture**Location:** Reedsport, Oregon**CWI Name:** Mike Inman and Tony Corsaletti**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Skyway Traveler Rail Replacement and Barrier**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) representative was present at American Bridge Manufacture for observations related to welding, fabrication and Inspection performed for the Skyway Traveler Rail Replacement and Barrier Cover Plates scheduled for this project. While onsite the QA Inspector observed the following.

At the time of arrival, the QA Inspector met with ABM Quality Control (QC) Inspector and discussed the welding operations and other items related to this project for this date.

During the shift at approximately 1330 hours, the QA Inspector had conference meeting between American Bridge Manufacture (ABM) Project Manager Todd Pannell and Quality Control Manager David Speakman. Multiple discussions regarding fabrication and material release were addressed during the meeting. After the meeting was completed, the QA Inspector contacted QA Task Leader Michael Foerder and provided with detailed information of the discussions addressed during the meeting.

Skyway Traveler Rail Replacement - CCO # 24S0

The QA Inspector periodically observed American Bridge Manufacture (ABM) welding personnel Mike Herbert and Joe Lacortt performing base material preparation and welding operations. The welding operation was being performed by using the Flux Cored Arc Welding Gas Shielded (FCAW-G) process in the flat position and it was being performed to make build-up (butter) incorrect cut material. The welding operation was being performed on assembly plate member identified as TR3033A and TR3030A scheduled to be incorporated into the Skyway Traveler Rail Replacement Assembly Mark # 3033TR1 and 3034TR1. The QC Inspector notified to QA Inspector,

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ABM has made a decision to build-up the cut notches instead of fitting the plate as is. Please see note below:

NOTE: The plates were delivered to ABM from Farwest Steel with cut notches instead of cut bevels, a total of four notches were cut per plate and a total of four plates were delivered with the same discrepancy.

The QA Inspector previously notified Structural Materials Representative (SMR) Adam Craig (in behalf of Gary Thomas) and QA Task Leader Michael Foerder of the discrepancy mentioned above.

The QA Inspector verified the electrical welding parameters and they appeared to be in general compliance with the referenced Welding Procedure Specification (WPS) number ABM-SAS-08. The QA Inspector observed QC Inspector monitoring the welding operation at this location. The welding operation was completed on the plate number TR3033A and the welding operation was not completed on the plate number TR3030A at this location during the QA Inspector's shift.

Barrier Cover Plates Coating - CCO # 227

The QA Inspector was notified by ABM QC Inspector Antony Corsaletti that the coating operation had been completed on the Barrier Cover Plates during the last shifts and that the final visual and testing inspections were in progress at this moment. The QC Inspector notified to QA Inspector that the Adhesion Test was scheduled for tomorrow morning and that the material was ready for visual verification by the QA Inspector. The QA Inspector performed random visual verification on the coated material and observed overspray was shown on the far side of the cover plates. The QA Inspector notified QC Inspector of the discrepancy observed and QC Inspector performed visual verification in the presence of the QA Inspector. The QC Inspector confirmed the overspray was present on the material and relayed to the QA inspector he will notify the QBM Project Manager Todd Panell of the oversprayed material.

Later during the shift, the QA Inspector was notified by ABM Project Manager the following: as per the Prime Contractor's request the material was needed at the job site for installation and that ABM would like to deliver the material as is if it was acceptable by the Caltrans Engineer.

The QA Inspector contacted Structural Material Representative (SMR) Aghili Parinaz (in behalf of Gary Thomas) and QA Task Leader Michael Foerder and provided with digital images and detailed information of the over sprayed material and the ABM request. Later during the shift, SMR relayed to the QA Inspector, after several discussions between METS and Caltrans Construction Representatives it was agreed that the material meets the fit for purpose requirements and that the material could be release to the job site as is by using a blue tag method. The QA Inspector notified ABM Project Manager of the information provided by the SMR.

Please note that it was late on the shift and the QA Inspector did not complete the material release on this date, the QA Inspector notified Project Manager that the material release would be completed tomorrow during the early shift.

Summary of Conversations:

As noted on the body of the report above. Other Basic communication was performed between the QA Inspector and the Quality Control Inspector during observations.

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Medina,Ricardo	Quality Assurance Inspector
Reviewed By:	Foerder,Mike	QA Reviewer
